

# Work Order ID 54220

December 3, 2009 12:46:09 PM



Page 1

Item ID: D3121-141  
Revision ID: E  
Item Name: Bracket Assembly

Accept



Setup Start



Stop



Start Date: 12/03/09 Start Qty: 12.00  
Required Date: 12/11/09 Req'd Qty: 12.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan:  
QC:

Date:  
Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
D3121	Rev E

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks: (1.250" x 2.000") 6.600" long

0.00

0.00

*Handwritten signature*  
*DI 09/12/18*

*(12)*

110



HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111 2-Deburr 3-Scribe batch number

0.00

0.00

*H.A 09/12/20*

*(12)*

*1*

*PTO 3 AM 11 PAGE*

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

*H.A 09/12/20*

*09-12-27*


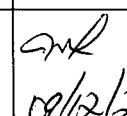
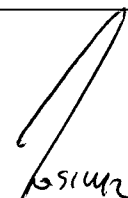
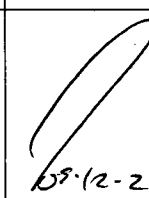
*(12)*

*1*

O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-141 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 54220		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/12/20	110	1 part have .188 rad instead of .250. RC → wrong tool had been put on setup buggy Tool have been removed and changed after 1st part		Scrap des trax & replace qty 1	M. A 09/12/20	 09/12/29		 09-12-29

NOTE: Date & initial all entries

# Work Order ID 54220

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Page 2

Item ID: D3121-141  
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Item Name: Bracket Assembly

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Setup Start



Stop



Start Date: 12/03/09 Start Qty: 12.00  
Required Date: 12/11/09 Req'd Qty: 12.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

mf 04/12/29

12

140



Small Fab

Small Fab

Small Fab

Memo

Assemble D3121-141 as per Dwg D3121.

0.00

0.00

9509/01/04 12

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

278 10/01/05

12

# Work Order ID 54220

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Page 3

Item ID: D3121-141  
Revision ID: E  
Item Name: Bracket Assembly

Accept



Setup Start



Stop



Start Date: 12/03/09 Start Qty: 12.00  
Required Date: 12/11/09 Req'd Qty: 12.00  
Reference:



Cust Item ID:  
Customer:

Approvals: Process Plan:  
QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start  
Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location 235A

0.00



Packaging

Memo

0.00

Packaging

10-1-5

(12x) SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/06 HJ

W 10-01-05

# Picklist Print

December 3, 2009 12:46:08 PM

Page 1

Work Order ID: 54220

Parent Item: D3121-141RevE

Parent Item Name: Bracket Assembly


Comments:

Start Date: 12/03/09

Required Date: 12/11/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3121-21RevE		Manufactured	No			140	Each	71.0000	12.0000			
												
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

71

46032

5

50096

10

52518

56

D3121-241RevE

Manufactured

No

100

Each

54.0000

12.0000



Bearing Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

54

52592

54

M174B1.250X02.000

Purchased

No

140

f

1.8389

6.9474



17-4 SS Bar 1.250 x 2.00

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

1.83894736

109851

1.83894736

~~1.25" x 2.500" M113437~~

17-4SS

1.25"x2.500"

M113437

6.6(F)

DA 09/12/18

DART AEROSPACE LTD		Work Order: 54720
Description: Bracket		Part Number: D3121-111
Inspection Dwg: D3121	Rev: E	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

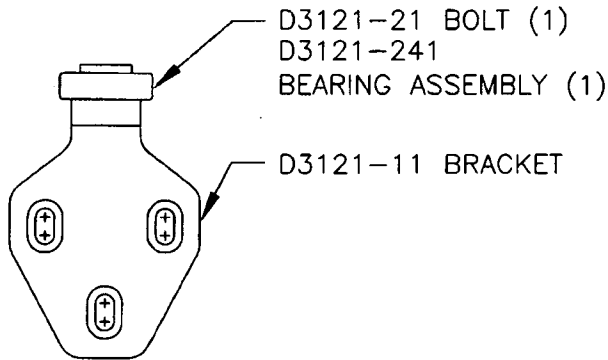
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	Ø0.3935	✓			
0.75	+/-0.030	0.750	✓			
0.375	+/-0.010	0.375	✓			
2.14	+/-0.030	2.137	✓			
1.96	+/-0.030	1.960	✓			
0.280	+/-0.010	0.279	✓			
3.330	+/-0.010	3.330	✓			
3.630	+/-0.010	3.629	✓			
R0.25	+/-0.030	R0.250	✓			
R0.375	+/-0.010	R0.375	✓			
Ø0.201	+0.005/-0.001	Ø0.204	✓			
0.100	+/-0.010	0.100	✓			
4.580	+/-0.010	4.579	✓			
6.18	+/-0.030	6.190	✓			
5.89	+/-0.030	5.887	✓			
0.080	+/-0.010	0.080	✓			
0.300	+/-0.010	0.300	✓			
30°	+/-0.1°	30°	✓			
R0.25	+/-0.030	R0.250	✓			
0.130	+/-0.010	0.131	✓			
0.664	+/-0.010	0.663	✓			
0.381	+/-0.010	0.388	✓			
0.201	+/-0.010	0.202	✓			
0.400	+/-0.010	0.401	✓			
0.580	+/-0.010	0.584	✓			
100°	+/-0.1°	100°	✓			
0.032	+0.000/-0.010	0.031	✓			

Measured by: H.A.	Audited by: amf	Prototype Approval: N/A
Date: 09/12/20	Date: 09/12/29	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
E	08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD	

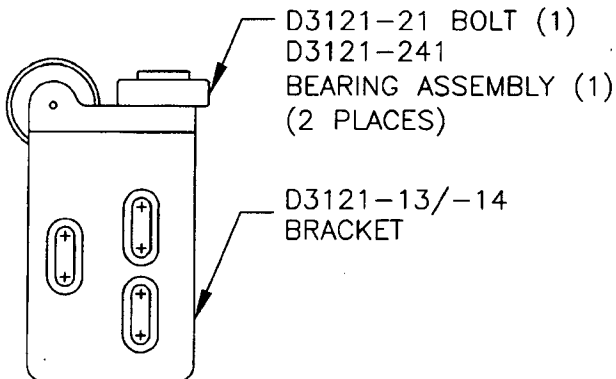
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07.11.07

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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

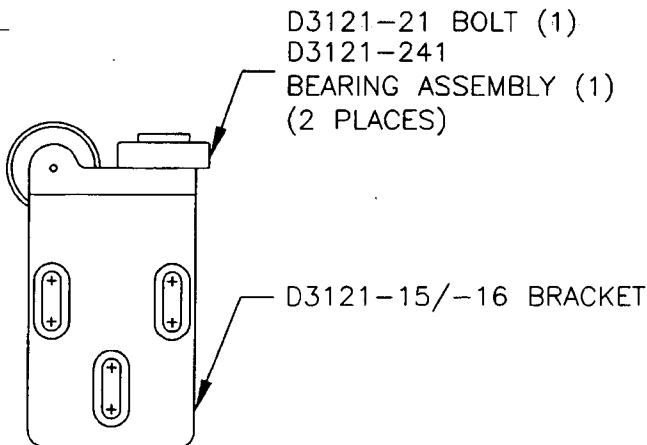


**D3121-041 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-33)

*Wb 54220*



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-37/-38)



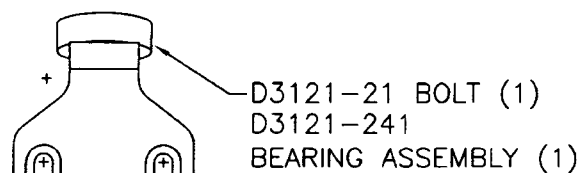
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(REPLACES PREMIER P/N B30-23000-35/-36)

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**DART**

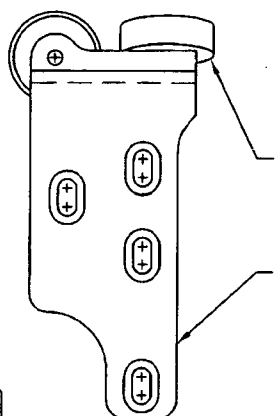
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-111 BRACKET

**D3121-141 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23001-01)

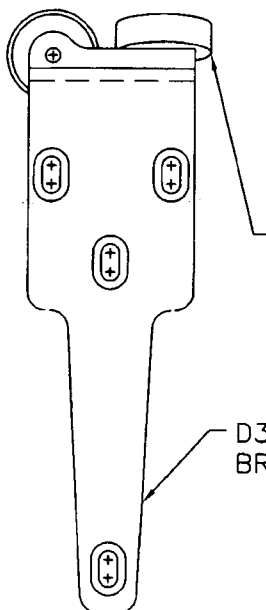
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07.11.07 W



D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-03/-04)

W/S  
54220



D3121-115/-116  
BRACKET

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-05/-06)

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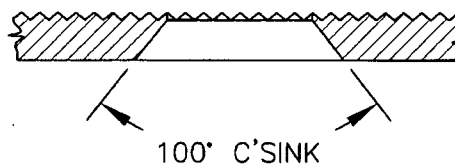
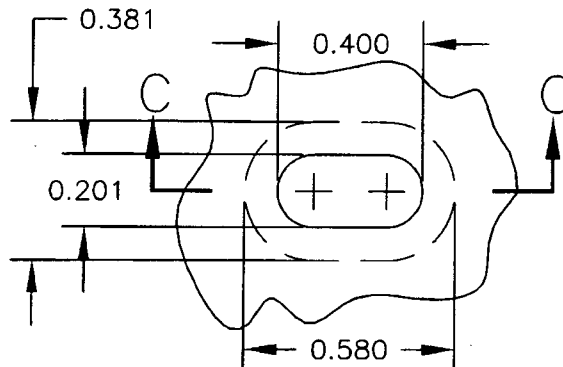
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 3 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**DETAIL A:  
SLOT DETAIL**  
SCALE 2:1  
VIEW ROTATED

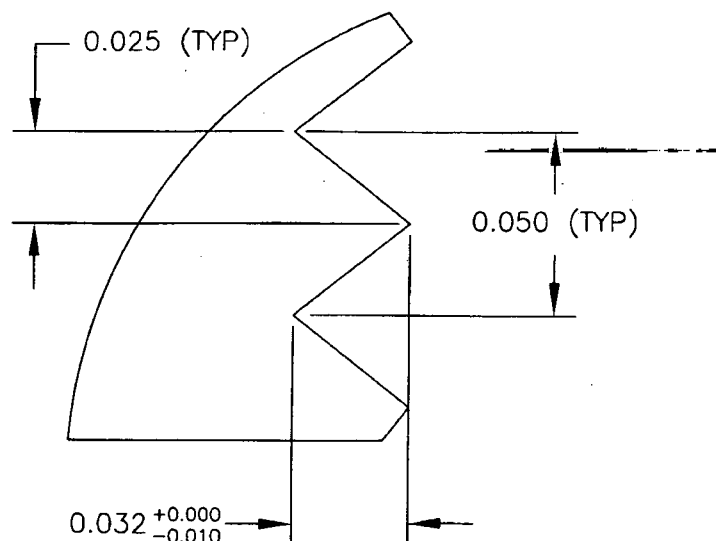


**SECTION  
C-C**

*ulb 54220*

**RELEASED**  
07.11.07

**DETAIL B:  
RIDGE DETAIL**  
PARTIAL SECTION  
SCALE 1:20

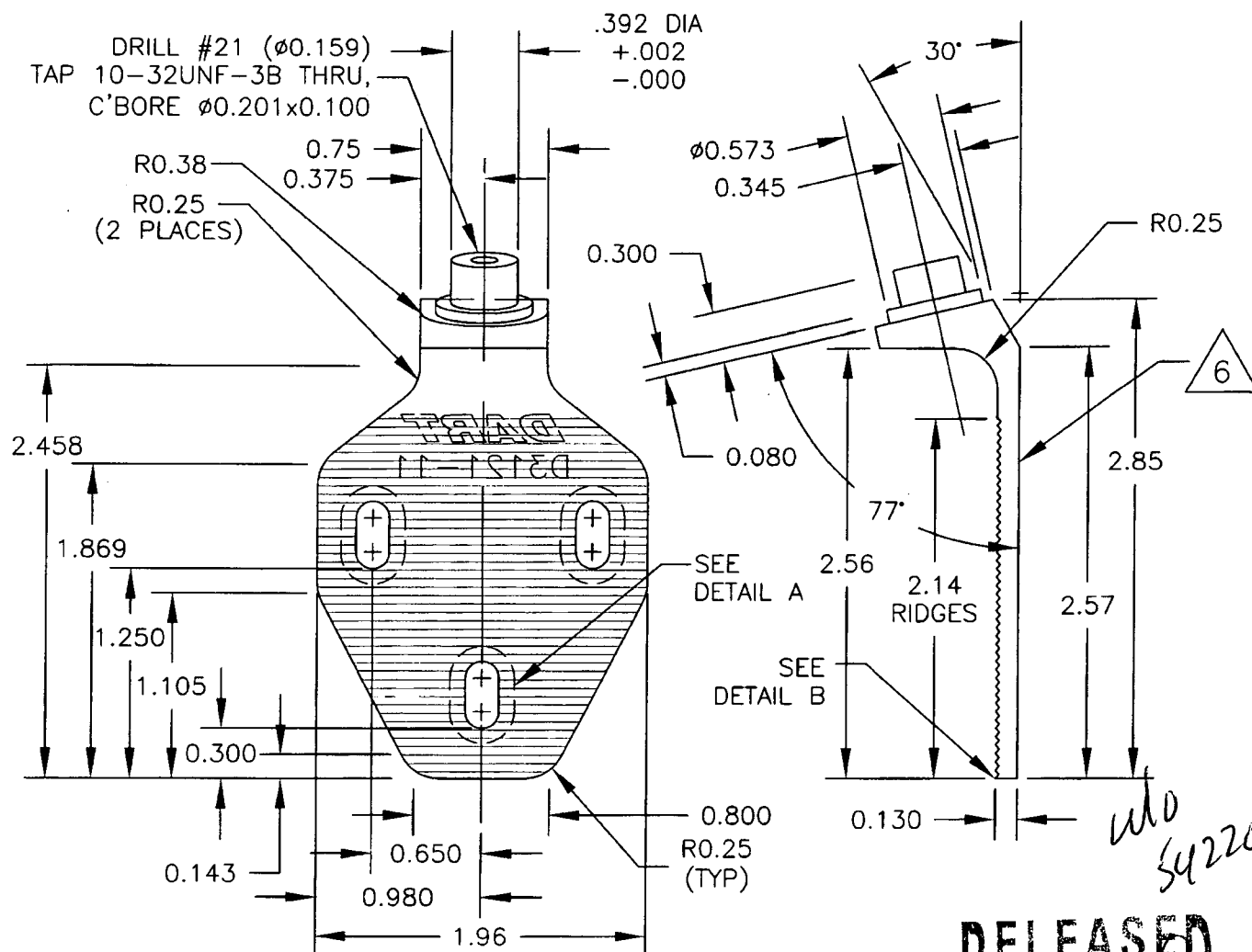


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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 4 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-11 BRACKET**

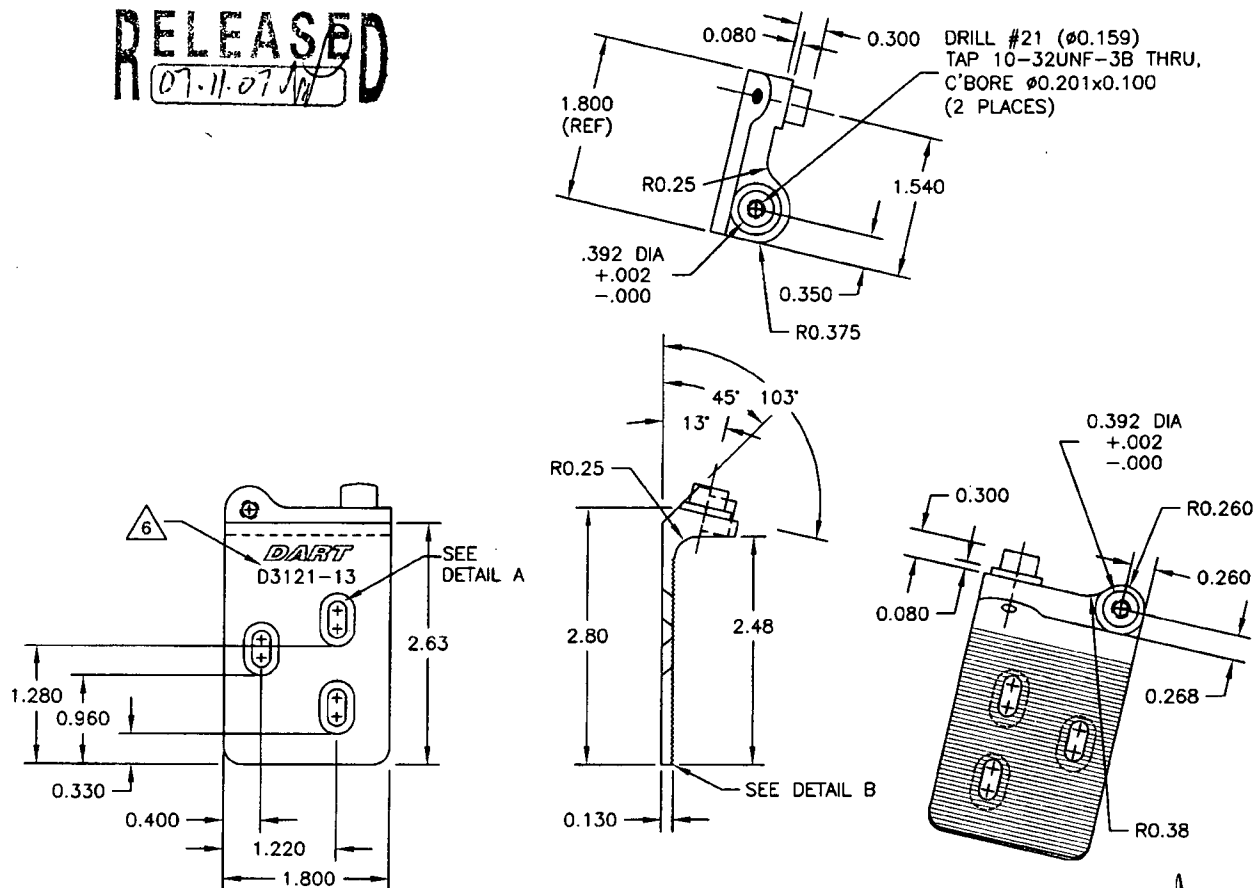
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MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 5 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
07.11.07*who 54220***D3121-13 BRACKET (SHOWN)****D3121-14 BRACKET (OPPOSITE)**

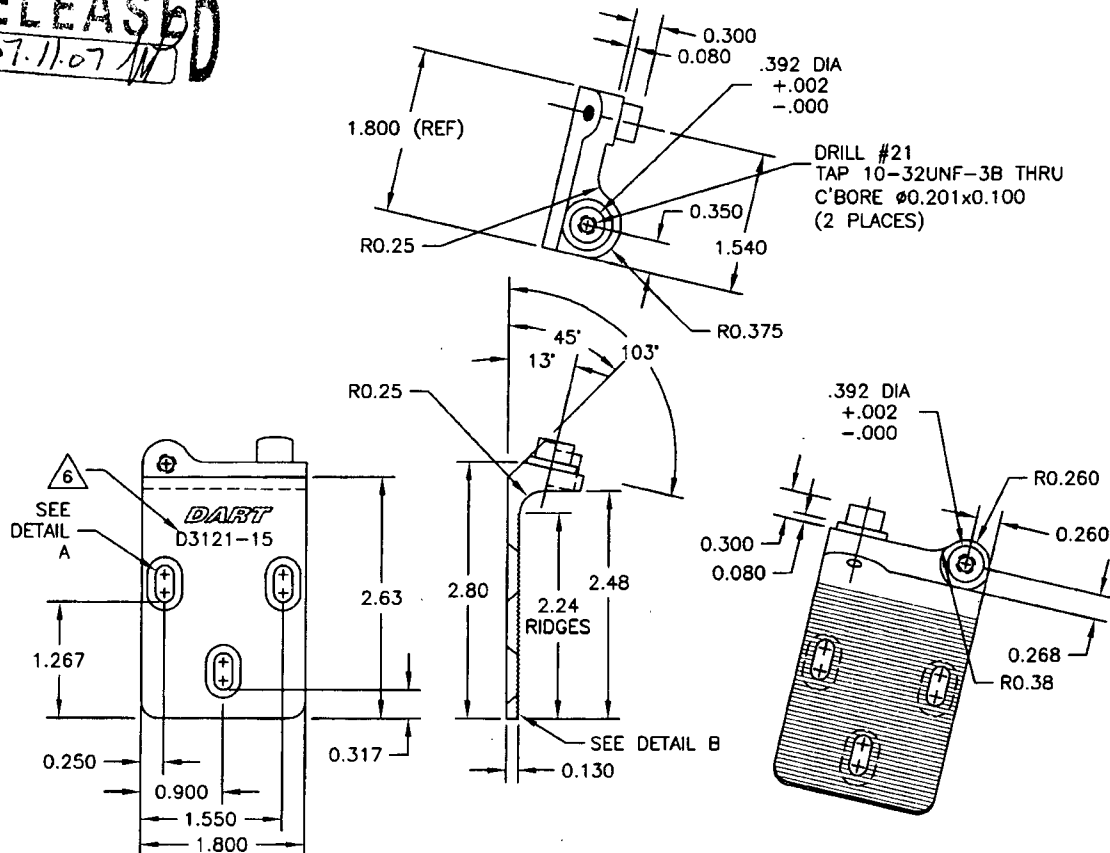
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MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 6 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
07.11.07**D3121-15 BRACKET (SHOWN)****D3121-16 BRACKET (OPPOSITE)**

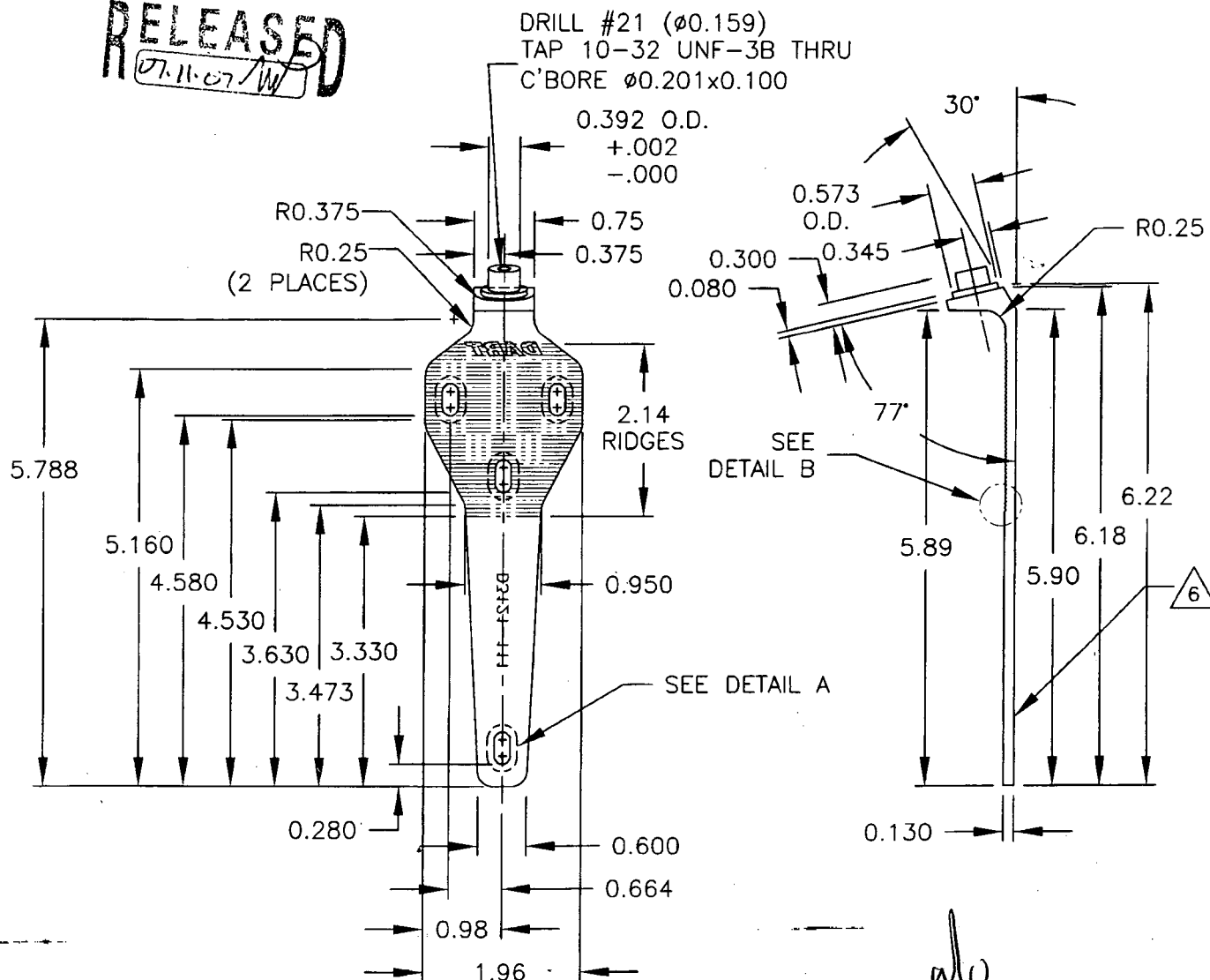
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MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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**DART**

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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 7 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
07.11.07/W**D3121-111 BRACKET**

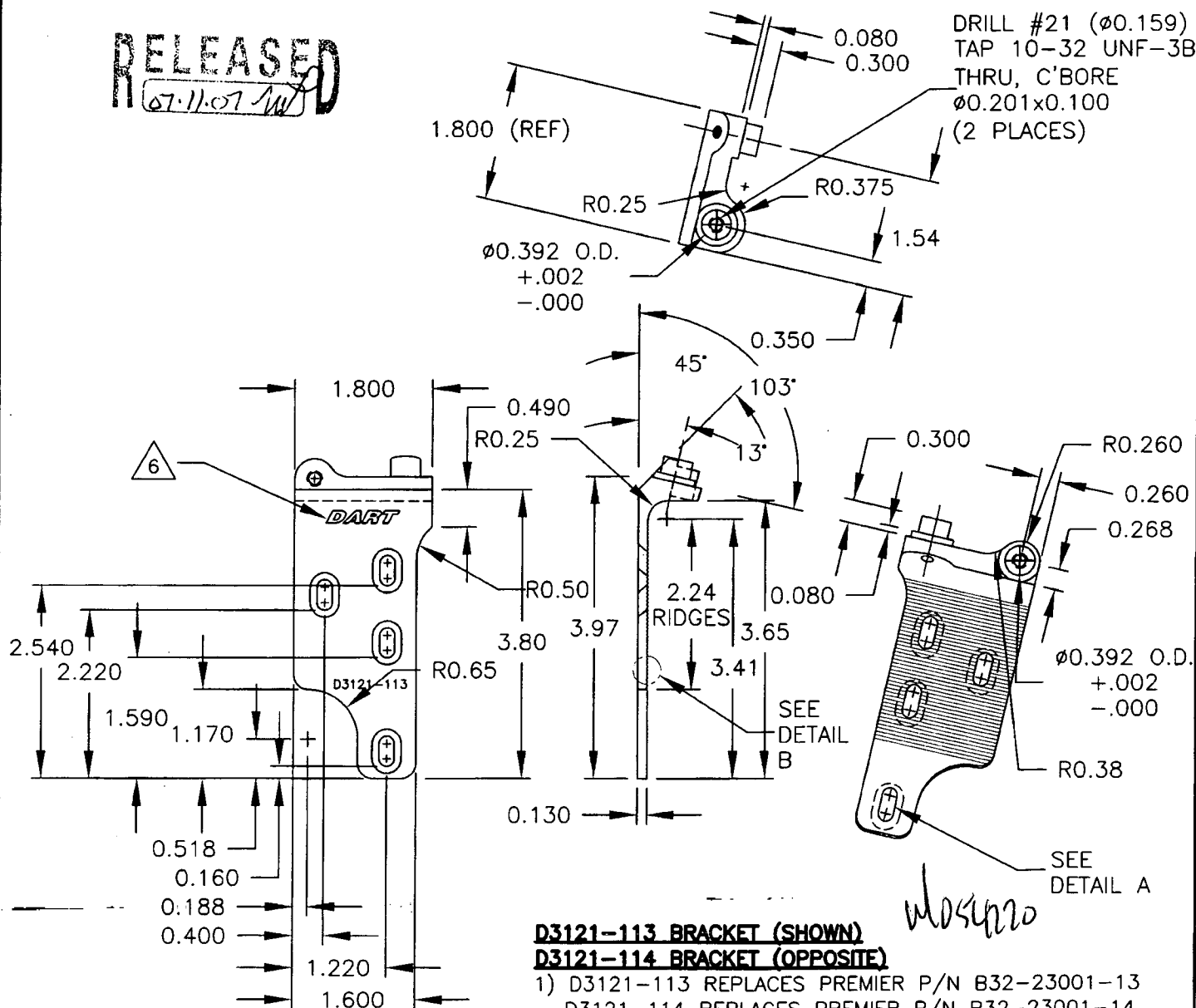
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MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 8 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED  
07.11.07

**D3121-113 BRACKET (SHOWN)**  
**D3121-114 BRACKET (OPPOSITE)**

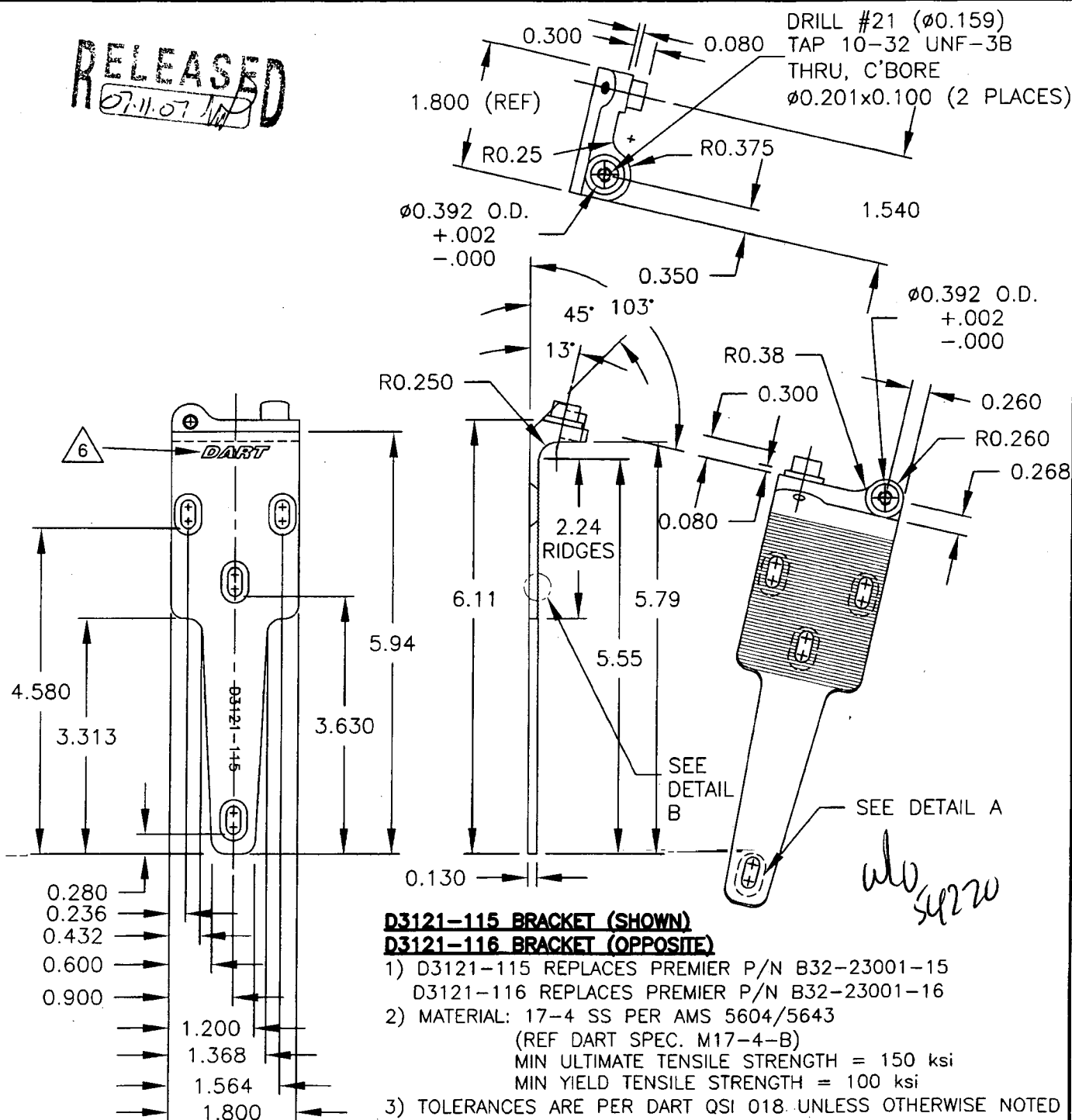
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D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 9 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
07.11.07

**D3121-115 BRACKET (SHOWN)**  
**D3121-116 BRACKET (OPPOSITE)**

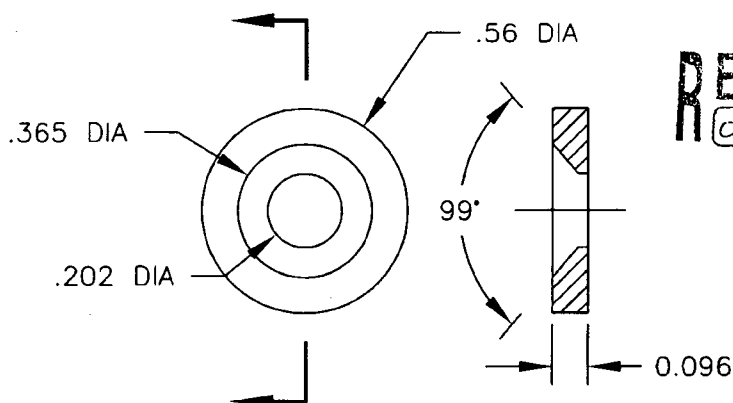
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D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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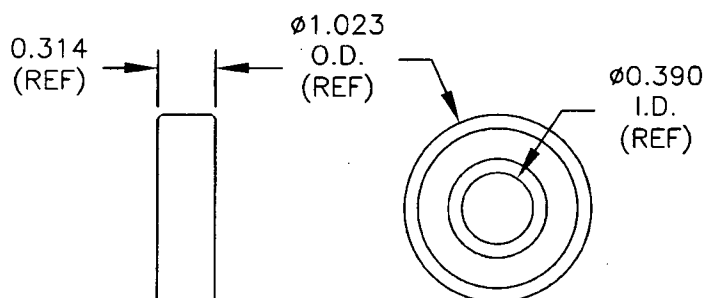
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**DART**

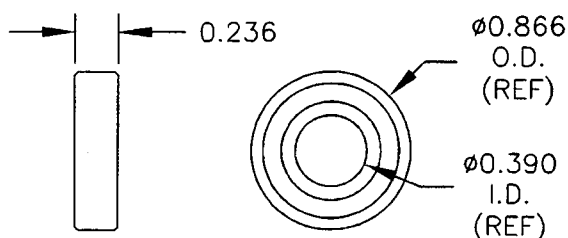
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

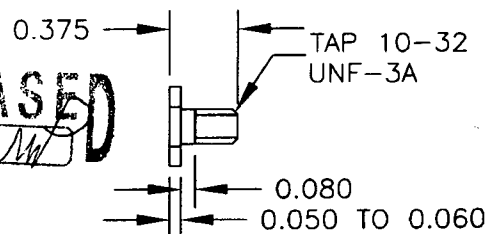
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

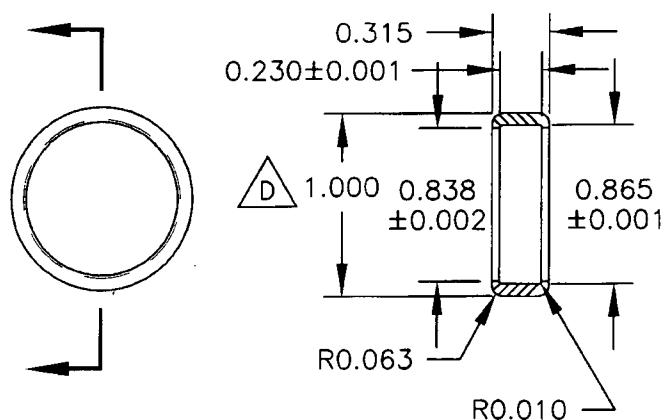
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

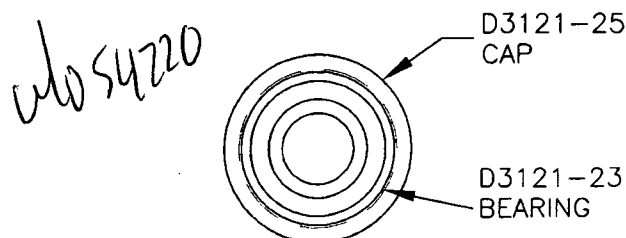
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, 1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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